

Work Order ID 92914

November-12-12 3:26:22 PM

92914

Page 1

Item ID: 649.4902
Revision ID:
Item Name: Lower Cutter Assembly

Accept

N9000040100

Setup Start ***NS1***
Stop ***NS2***

Start Date: 12/11/2012 Start Qty: ~~10.00~~ ***10***
Required Date: 03/12/2012 Req'd Qty: ~~10.00~~ ***10***

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12-11-12 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
649.4900	A

110	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--

110

Packaging	Memo	0.00							
-----------	------	------	--	--	--	--	--	--	--

Packaging

120		0.00							
-----	--	------	--	--	--	--	--	--	--

120

Small Fab	Memo	0.00							
-----------	------	------	--	--	--	--	--	--	--

Small Fab	Assemble as per dwg								
-----------	---------------------	--	--	--	--	--	--	--	--

130	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

130

QC	Memo	0.00							
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Quality Control

DAS

27

9-89

14/6/3

2 0 0 AP
14-6-2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Work Order ID 92914

November-12-12 3:26:22 PM

92914

Page 2

Item ID: 649.4902

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Item Name: Lower Cutter Assembly

Stop ***NS2***

Start Date: 12/11/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 03/12/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Identify as per dwg & Stock Location:

0.00

140

Packaging

Memo

0.00

Packaging

***IDENTIFY AS DWG PER APICAL MPP-120 BY LASER ETCH THE P#
AND REV***

14/6/6 (2)

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

14/6/9

14.6.9

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
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Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

November-12-12 3:26:27 PM

Page 1

Work Order ID: 92914

Parent Item: 649.4902

Parent Item Name: Lower Cutter Assembly

92914

649 4902

Start Date: 12/11/2012

Required Date: 03/12/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 12.11.01 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
649.8301 *649 8301* Cutter Sub Assembly		Manufactured	No		108846		Each	0.0000	**	2		AS 14-6-2	
649.5301 *649 5301* Lower Deflector Assembly		Manufactured	No		108846 M27615		Each	0.0000	**	2		AS 14-6-2	
MS27039-08-19 *MS27039-08-19* Screw		Purchased	No		108846		Each	700.0000	**	28		AS 14-6-2	
					124309					6			
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST307			100						
					123525		100						
				ST308			600						
					123352		600						
NAS1149FN832P *NAS1149FN832P* Washer		Purchased	No				Each	923.0000	**	60		AS 14-6-2	
					123900					12			
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				275			198						
					122441		198						
				ST275			125						
					115158		125						
				ST294			600						
					123352		200						
					123522		400						

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
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FAULT CATEGORY												
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Picklist Print

November-12-12 3:26:27 PM

Page 2

Work Order ID: 92914

92914

Parent Item: 649.4902

649 4902

Parent Item Name: Lower Cutter Assembly

Start Date: 12/11/2012

Required Date: 03/12/2012

Start Qty: 10.00

Required Qty: 10.00

MS21042L08

Purchased

No

Each

890.0000

30

MS21042L 08

**

Nut

128429

⑥

AS 14-6-2

Location

Loc Qty

Loc Code

315

9

122452

9

ST315

500

122814

500

ST317

381

122141

381

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTIC. NO. 03526

SHEET 1 OF 1

DWG NO. 649.4900

REV: A

PREPARED BY S. COCHRAN

DATE: 05-29-12

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: CUTTER ASSY

APPROVED BY: ENGR

MFG

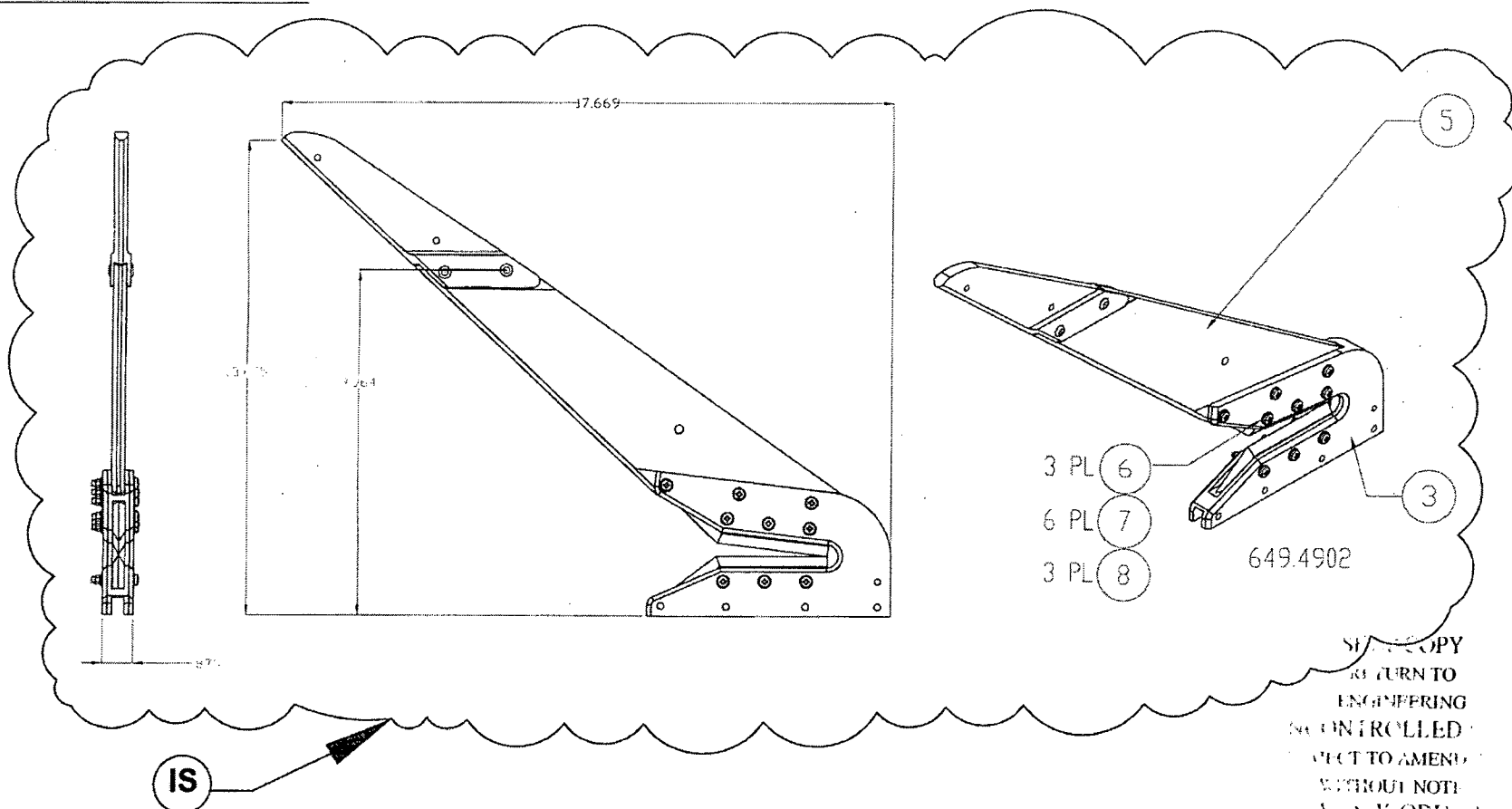
QC

EFFECT
CURRENT STOCK & NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: REVISED INSPECTION DIMENSIONS

SHEET 1, ZONE D2 IS:



STAMP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
DO NOT TO AMEND
WITHOUT NOTI
FICATION OR
WORK ORDER

929.14 MJS
12-11-12

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ BOM

CHANGE CATEGORY
☐ MAJOR ☒ MINOR

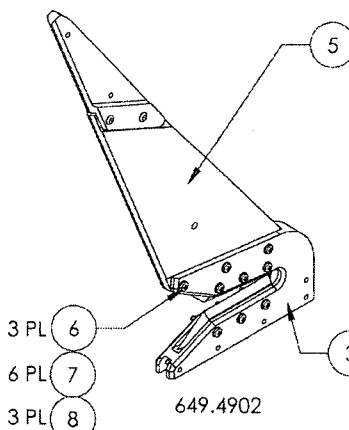
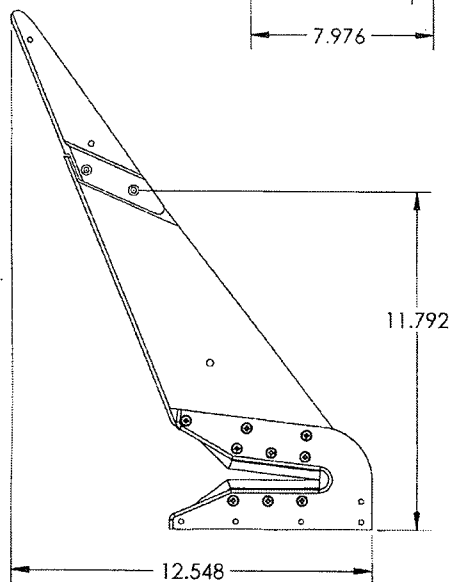
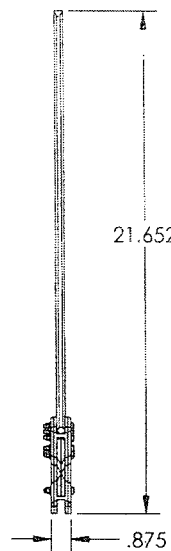
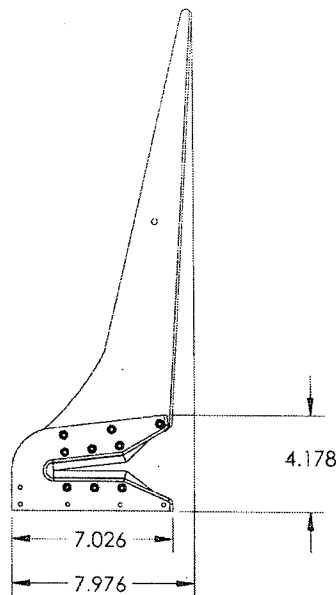
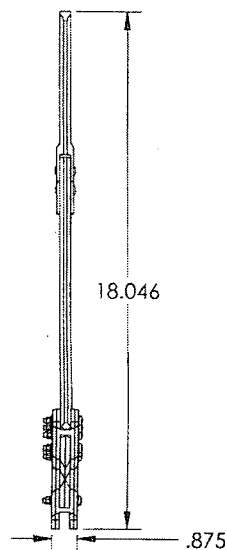
DER REVIEW REQUIRED
☐ YES ☒ NO

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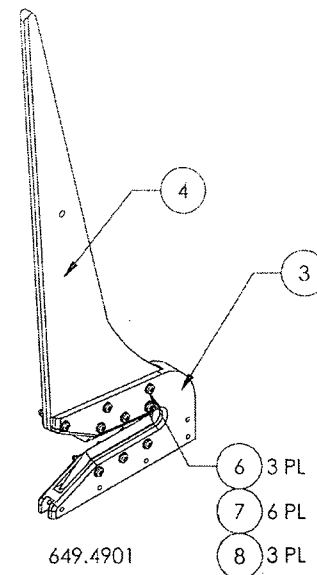
1. IDENTIFY IAW MPP-120.

UNINCORPORATED ECN(S)

03526



REV.	DESCRIPTION	DATE	APPROVED
1	INITIAL RELEASE	12-01-11	NEW
2	INITIAL RELEASE	12-01-11	NEW
3	INITIAL RELEASE	12-01-11	NEW



3	3	8	601.1541	LOCKNUT	MS21042L08	
6	6	7	601.2764	WASHER	NAS1149FN832P	
3	3	6	601.2765	SCREW	MS27039-0819	
1		5	649.5301	LOWER DEFLECTOR ASSY		
1	1	4	649.5311	UPPER DEFLECTOR		
1	1	3	649.8301	CUTTER SUB ASSY		
		2	649.4902	LOWER CUTTER ASSY		
		1	649.4901	UPPER CUTTER ASSY		
4902	4901	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
PARTS LIST						
APICAL INDUSTRIES						
2608 TEMPLE HEIGHTS DR.						
OCEANSIDE, CA. 92056-3512 (760)724-5300						
CUTTER ASSY						
UNLESS OTHERWISE SPECIFIED						
DIMENSIONS ARE IN INCHES						
TOLERANCES ARE:						
FRACTIONS DECIMALS ANGLES						
3 PLACES 2 PLACES 1 PLACE						
ANGLES 1/2 1/4 3/8						
SCALE NONE						
SHEET 1 OF 1						

92914